

000280



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-567-145
Job Sheet 170917



Part No: D350-567-145

Job Qty: 1 ea

Part Name: Floor Window Close Out (AS350 B3e)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 2/13/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/13/18	0.00	0.00	Start Up Stores/Pkg-2		JAN 30 2018 W.K.
110	Packaging	1 pcs		2/13/18	0.00	0.00	Packaging1-3		FEB 16 2018
120	QC	DAS		2/13/18	0.00	0.00	QC4		
125	DC	35		2/13/18	0.00	0.00	DC		
130	Packaging	980		2/13/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		2/13/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea)	90-Start up Operation	
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	
CB200	Acrylic Adhesive, 3.5G	1 pcs (1 ea)	90-Start up Operation	
D3802-1-024 X1	Window Seal (\$ Per Foot)	2 Ea (2 ea)	90-Start up Operation	
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	
D4441-1-024 X1	Rubber Seal	2 Ea (2 ea)	90-Start up Operation	
D4730-020-030	Velcro Strip 2.0W/ X 3.0L	1 Ea (1 ea)	90-Start up Operation	
D4971-041	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	
D5076-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	
NAS1149F0332P	Washer	10 Ea (10 ea)	90-Start up Operation	
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	5	377	0
	AN525-10R6	2	306	0
	AN525-832R7	2	78	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

CB200	1	35	0
D3802-1	2	196	0
D4435-9	2	3	0
D4436-041	1	2	0
D4441-1	2	172	0
D4730-020-030	1	3	0
D4971-041	1	1	0
D5076-041	1	2	0
MS21042L06	7	264	0
MS21042L08	2	2,034	0
MS21042L3	5	2,828	0
MS21059L3	2	227	0
MS35206-229	7	81	0
NAS1149F0332P	10	5,495	0
NAS1149FN616P	14	163	0
NAS1149FN816P	2	258	0

Part Specifications

Specifications could not be found.

Plex 1/24/18 9:10 AM dart.poulin.mario



Container No: S037190



Part: D350-567-145

Job No: 170917

Serial No/Batch: S037190

Revision: DSI 9590

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/27/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000280

Tel (613) 632-5200

Containers on Master Unit 000280				
Serial No	Part No	Customer Part No	Status	Quantity
S037187	AN3-3A	AN3-3A	Allocated	0
S037186	AN525-10R6		Allocated	0
S037184	AN525-832R7		Allocated	0
S000671	CB200		Allocated	1
S037165	D3802-1		Allocated	0
S017527	D4435-9		Allocated	1
S043289	D4435-9		Allocated	1
S031039	D4436-041		Allocated	0
S037134	D4441-1		Allocated	0
S037124	D4730-020-030		Allocated	0
S007315	D4971-041	D4971-041	Allocated	0
S037121	D5076-041		Allocated	0
S037119	MS21042L06	MS21042L06	Allocated	0
S037118	MS21042L08		Allocated	0
S037117	MS21042L3	MS21042L3	Allocated	0
S037115	MS21059L3	MS21059L3	Allocated	0
S037113	MS35206-229		Allocated	0
S037112	NAS1149F0332P		Allocated	0
S037111	NAS1149FN616P		Allocated	0
S037110	NAS1149FN816P		Allocated	0

REF. ONLY

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

A

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kG	65.5 in 1.66 m	255.5 in-lb 2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE 15.01.12		COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	